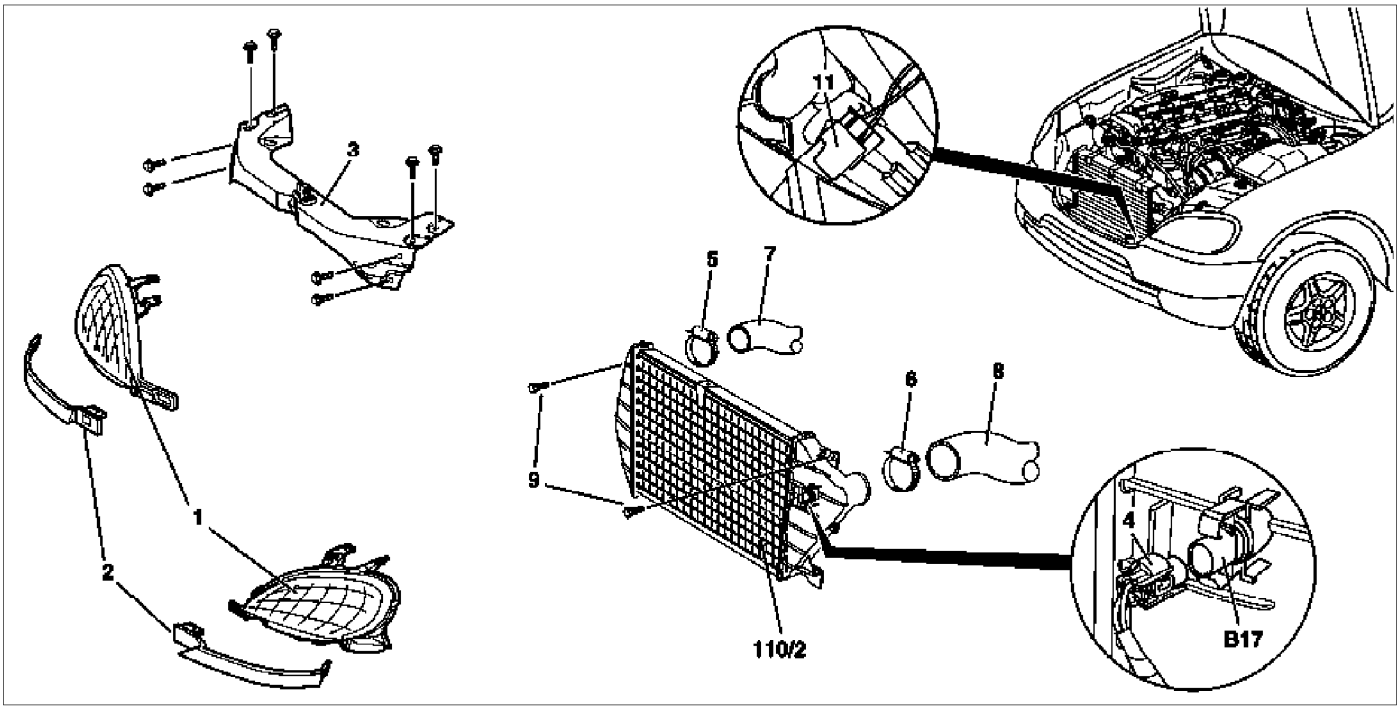
ENGINE 612.963 in MODEL 163.113



P09.41-2024-09

1	*Headlamp units*	5	*Right hose clamp*	9	*Bolts*
2	*Cover strips*	6	*Left hose clamp*	11	*Socket*
3	*Front end crossmember*	7	*Charge air hose to charge air cooler*	110/2	*Charge air cooler*
4	*Socket at temperature sensor*	8	*Charge air hose from charge air cooler*	B17	*Intake air temperature sensor*

Operation no. of operation texts or standard texts and flat rates

Sector	Op. no.	Operation text
P	096810	REMOVING AND INSTALLING CHARGE AIR COOLER
P	096820	REPLACING CHARGE AIR COOLER
P	096827	REPLACING CHARGE AIR COOLER (COOLER REMOVED)

	Removing, installing		
⚠ **Danger!**	**Risk of injury** from fingers becoming **jammed or bruised** when removing and installing and aligning hood, trunk lid, doors, lids and sliding roof	When moving components ensure that no body parts or limbs are in the area of motion.	AS00.00-Z-0011-01A
1	Open engine hood and position upright	Have an assistant secure hood	AR88.40-P-1000GI
2	Remove headlamp units (1)		AR82.10-P-4730GH
3	Remove front end crossmember (3)	ℹ Place over engine with release cable attached.	AR62.30-P-2300GH
4	Unplug socket (4) at intake air temperature sensor (B17)	Do not release or lock temperature sensor (B17) in place with socket plugged in otherwise the locking arms will be over-tensioned. Refer to: # Removing and installing intake air temperature sensor.	AR07.52-P-1465A
5	Detach hose clamps (5, 6) of the charge air hoses (7, 8) at the charge air cooler (110/2)		
6	Unscrew bolts (9) at charge air cooler		
7	Remove charge air cooler (110/2)	ℹ Detach from charge air hoses. ℹ Traces of oil, slight quantities of oil in the charge air hose come from the crankcase ventilation and are permissible.	
8	Install in the reverse order		

9 e	Check headlamp adjustment and if necessary correct. Check and correct headlamp adjustment	MODEL 124, 129, 140, 163, 202 MODEL 170, 208, 210 except CODE (491) USA version	AP82.10-P-8260A
10	Read fault memory, erase	Stored faults which can result from cables being disconnected or from simulation during removal and installation or test work, have to be processed and erased in the fault memories after completing the work. Refer to: #	
		STAR DIAGNOSIS	